

Work Order ID 139666

Monday, November 30, 2015 11:09:37 AM

139666

Page 1

Item ID: D3984

Revision ID:

Item Name: Rubber Extrusion, X-Tube, Per Foot

Start Date: 12/2/2015 Start Qty: 50.00

Required Date: 12/2/2015 Req'd Qty: 50.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan: MLJ

Date: DEC 03 2015

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3984	A								

100

0.00

100

Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: 30650
Rubber extrusion
Possible Supplie: Accurate rubber
P/N: 110750006
Material release note required

CL DEC 03 2015 100

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.02

Packaging

Ensure material release note is attached

100 SP 15-D-21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
				OTHER :							

Work Order ID 139666

139666

Monday, November 30, 2015 11:09:37 AM

Page 2

Item ID: D3984 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rubber Extrusion, X-Tube, Per Foot
 Start Date: 12/2/2015 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 12/2/2015 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							DAS 9 9-89
120						(b)	15-12-24		
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location <u>S413</u>	0.00							
130						100	DAS 6 9-89		
Packaging	Memo	0.01							JAN 04 2016
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.08				MCS			JAN 05 2016
Quality Control									

JAN 04 2016

MCS

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Monday, November 30, 2015 11:09:37 AM

Page 1

Work Order ID: 139666

139666

Parent Item: D3984

D3984

Parent Item Name: Rubber Extrusion, X-Tube, Per Foot

Start Date: 12/2/2015

Required Date: 12/2/2015

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP rev A 09.11.12 new issue EC verified :DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
110750006		Purchased		No			f	0.0000					

110750006

Rubber Extrusion

**

~~50~~
100

100 x 805-2-21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

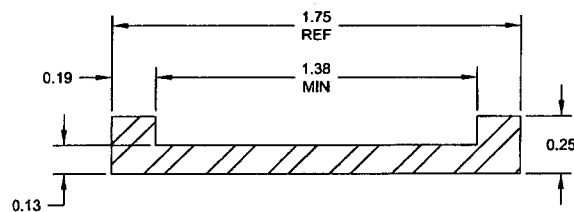
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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SPECIFICATION CONTROL DRAWING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 139-666 NLS
15-12-03



D3984-XXX

PART NUMBERING: D3984-035

BASIC PART ——— LENGTH IN TENTHS OF AN INCH

EXAMPLE: D3984-035 = PART 3.5 INCHES LONG
EXAMPLE: D3984-100 = PART 10.0 INCHES LONG

RELEASED
2009-11-11
MP

NOTES:

- 1) MATERIAL: NEOPRENE BLACK 50 DUROMETER
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) PREFERRED SUPPLIER: ACCURATE RUBBER (ACR GROUP), RICHMOND, B.C., CANADA.
PART NUMBER 110750006

A NEW ISSUE		AJS	09.11.06
REV.	DESCRIPTION		BY DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3984	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		RUBBER EXTRUSION, X-TUBE	NTS
DATE	09.11.06	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO30650

Purchase Order Date 12/3/2015

PO Print Date 12/3/2015

Page Number 1 of 2

Order From :

ACR GROUP INC.
12771 - NO. 5 ROAD
RICHMOND, BC V7A 4E9
CA

VC-ACR001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

Contact Name

Vendor Phone 604 274 9955

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
Line Comments			Promise Date				
Delivery Comments							

1	110750006	Rubber Extrusion	12/18/2015	Yes	100.00	\$5.50	\$550.00
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AS PER DWG ND3984 REV. A
B139666

12/18/2015

01/12/2016

Line Total: \$550.00

2	71401-45	PROCUREMENT QUALITY CLAUSES	12/18/2015	No	1.00	\$0.00	\$0.00
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Procurement Quality Clauses

A004 faa-pma/tso

A005 right of entry

A015 shelf life controlled material 60%

A016 personnel qualification

A017 raw material identification

A026 certification of material conformance

A041 Quality management system

A043 retention of quality documents

12/18/2015

PO Instructions: Fedex Acc#151793240

Note:

12/3/2015

615-12-28



www.acrgroup.ca

12771 No. 5 Road
Richmond, B.C.
Canada V7A 4E9

Tel: 604-274-9955
Fax: 604-274-1013
Toll Free: 1-888-478-2237

PACKING SLIP

CUSTOMER COPY

PACKING SLIP 00155944

CUSTOMER NO. 10750

PST#

S
O
L
D
T
O

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

S
H
I
P
T
O

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

DATE		SHIP VIA		TERMS		
12/17/15		FED-EX 0/N		ACR GROUP INC. NET 30 DAYS		
PURCHASE ORDER NUMBER		DATE ORDERED		SALES PERSON		
P030650		12/03/15		00155944 ROB		
QUANTITY		ITEM NUMBER	DESCRIPTION	UNIT	UNIT PRICE	AMOUNT
ORDERED	SHIPPED					
100	100	-	110750006	EXTRUSION DIE # 1234 50+/-5 "A" NEO DWG# D3984	FT	
FED-EX ACCT# 151793240			SUBTOTAL			
FED-EX OVERNIGHT			HST			
FREIGHT: Collect			TOTAL AMOUNT			

Quality Rubber Products To Your Requirements
Specialists in Bonding Natural and Synthetic Rubber To Metal
Molded and Extruded Rubber Products, Cast Polyurethane Specialties



12771 No. 5 Road
Richmond, B.C.
Canada V7A 4E9
Tel : (604) 274-9955
Fax : (604) 274-1013

CERTIFICATE OF COMPLIANCE

Date : 2015-12-17

Customer : Dart Aerospace LTD

Customer P.O. # : PO30650

ACR W.O. # : 155944

Item # : 110750006

Item Description: Extrusion 50 +/- 5 "A" NEO

ACR Compound : A - 106

Date Shipped: December 17, 2015

This Certifies that to the best of our knowledge the material delivered under this contract is in accordance with the terms of the contract, and with ACR Group quality standards.

Michael Reilander
(ACR GROUP INC. REPRESENTATIVE)